

Work Order ID 52533

September 29, 2009 12:52:54 PM



Page 1

Item ID: D3847-043 **GY** Accept

Revision ID: B

Item Name: FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Start Date: 09/30/2009 Start Qty: 2.00

Required Date: 10/12/2009 Req'd Qty: 2.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: MF Date: 09-09-29 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3847	B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3847

Dwg Rev: BProg Rev: B

2-Deburr if necessary

IB 9-9-30(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-9-30

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Item ID: D3847-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Start Date: 09/30/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

2) 502/01/30



/

Quality Control

130

Memo

0.00



Brake NC

form as per dwg D3847

0.00

SB 09/10/05

4

/

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) 502/01/05



/

Quality Control

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Item ID: D3847-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Start Date: 09/30/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 5 07/10/13



9

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Pc 9/10/13 (4)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/13

W 9-10-16

Picklist Print

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Page 1

Work Order ID: 52533



Parent Item: D3847-043RevB



Parent Item Name: FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Start Date: 09/30/2009

Required Date: 10/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3846-3RevB

Manufactured

No

Each

8.0000

2.0000



GASKET

B51829 (3P)



09/10/13

Warehouse

Loc Qty

Loc Code

B52677 (X)

Location

Main Warehouse

FP

8

51829

8

M304S18GA

Purchased

No

sf

154.6396

2.2737



4.5474



B943D

304/316 .050 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

154.6396053

108156

0.98526316

111743

23.7174

112178

129.936942

112178

DART AEROSPACE LTD		Work Order: S2533
Description: FWD W/FAR PLATE ASSY		Part Number: D3847-043
Inspection Dwg: D3847-3 Rev: 8		Page 1 of 1

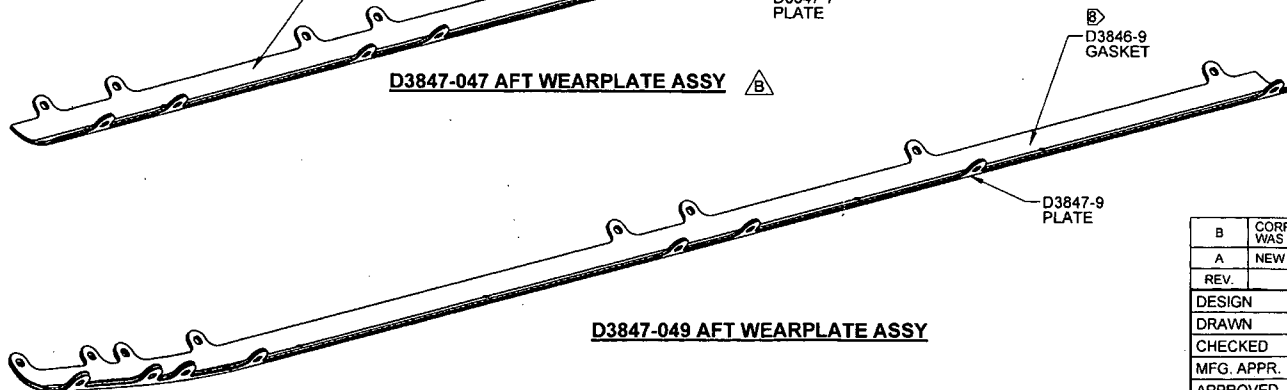
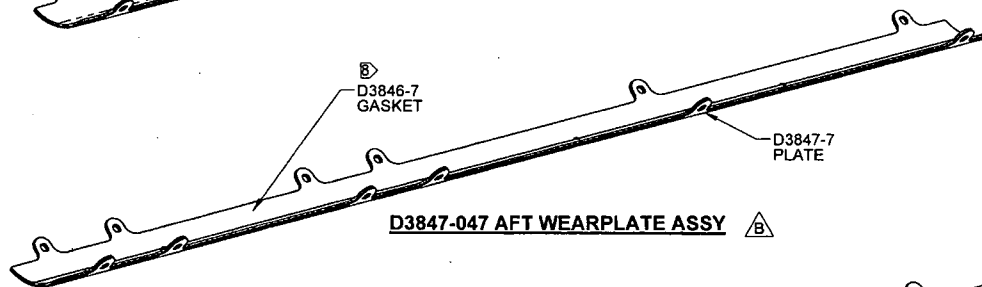
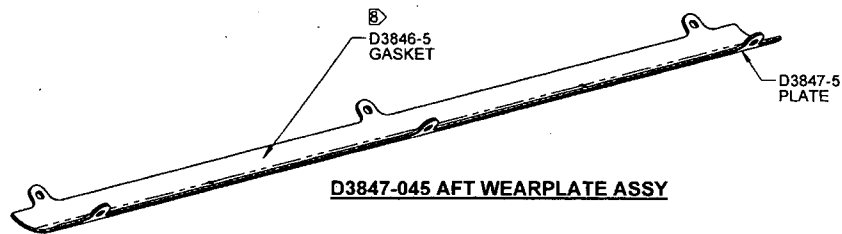
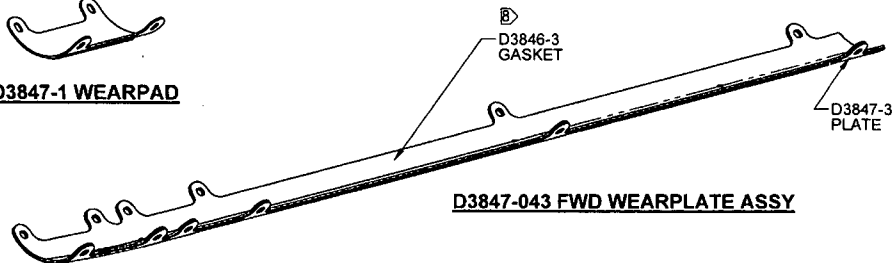
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.191	X			
300 X 300	± .010	304 X 309	X			
2.45	± .030	2.446	X			
.75	± .030	.749	X			
1.69	± .030	1.69	X			
6.88	± .030	6.877	X			
10.000	± .010	10.000	X			
18.000	± .010	18.000	X			
39.53	± .030	39.53	X			
3.280	± .010	3.279	X			
4.13	± .030	4.126	X			
14.484	± .010	14.484	X			
28.967	± .010	28.967	X			
32.467	± .010	32.467	X			
33.967	± .010	33.967	X			
37.467	± .010	37.467	X			
.050	± .010	.047	X			

Measured by: AB	Audited by: S	Prototype Approval:	N/A
Date: 9-9-30	Date: 09/09/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
15	1				D3846-3	GASKET
16		1			D3846-5	GASKET
17			1		D3846-7	GASKET
18				1	D3846-9	GASKET
31	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX" USING YELLOW PAINT MARKER AT INSIDE SURFACE
 - 7) WEIGHT: D3847-043 = 1.71 lbs
D3847-045 = 1.49 lbs
D3847-047 = 2.00 lbs
D3847-049 = 4.21 lbs
 - 8) BOND D3846-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

RELEASED
09/07/15

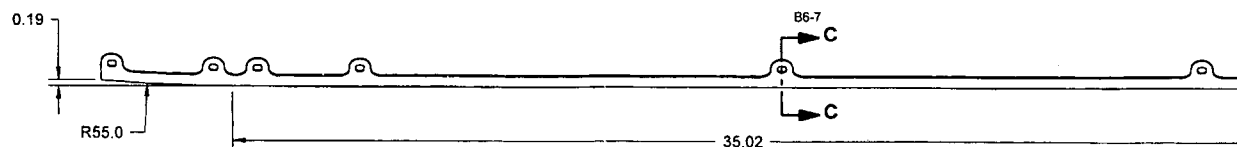
B	CORRECT TYPO D3847-047 WAS D3847-045. ZN B5-1; 5.82 WAS 6.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	09.06.30		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3847** REV. B
SHEET 1 OF 7

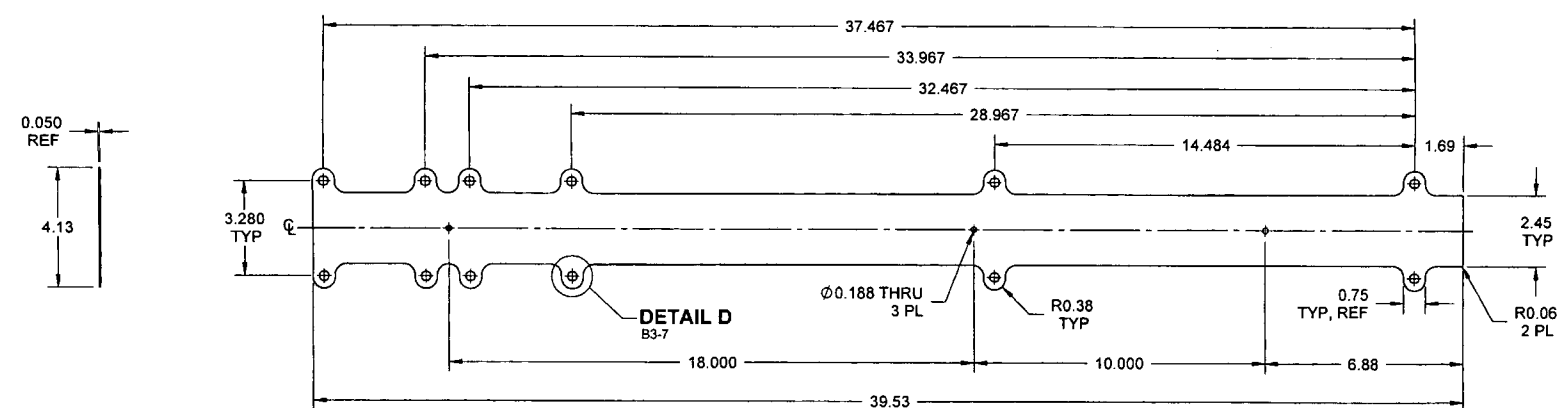
TITLE **WEARPLATE ASSY** SCALE NTS

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D3847-3 PLATE
MADE FROM D3847-3F FLAT PATTERN

#52533



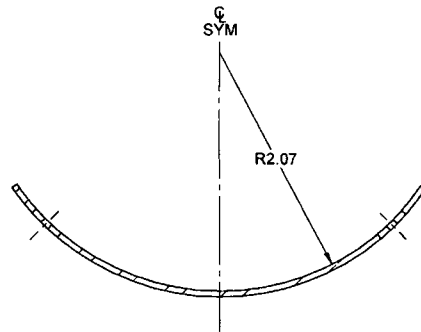
D3847-3F FLAT PATTERN

RELEASED
29/07/13

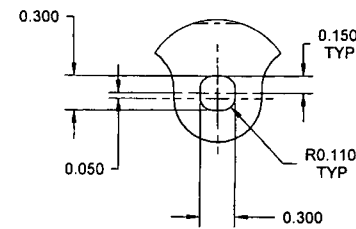
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.46 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>EE</i>	D3847	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.	<i>H</i>	WEARPLATE ASSY	NTS
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#52833



SECTION C-C
SCALE 4X
D4-3
D4-4
D3-5
D3-6



DETAIL D
TYP. SCALE 4X
B5-3
B6-4
B3-5
B5-6

RELEASED
09/67/15 MLD

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3847	REV. B SHEET 7 OF 7
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DATE	09.06.30		